

Work Order ID 65707

Monday, January 24, 2011 9:01:02 AM



~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4038-4

Accept



Setup Start



Revision ID:

Item Name: Angle, Aft, RH

Stop



Start Date: 1/24/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/26/2011 Req'd Qty: 2.00



Customer:



Reference:

Just 11.01.24

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4038

B U/R

Just 11.01.24

0.00

0.00

11.1.25

2

100



Bandsaw

Jeaspa Bandsaw

Memo

Cut Blank 7.625" long

0.00

0.00

11.1.25

2

110



HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg & Folio FA880

Dwg Rev:

Folio Rev:

Deburr

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Page 2

Item ID: D4038-4

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Stop



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Start Date: 1/24/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/26/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	11.1.25			2	✓		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL 11/01/25			2			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2			BR 11-01-26

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Page 3

Item ID: D4038-4

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle, Aft, RH

Start Date: 1/24/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/26/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: G.A

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11/01/26 AUTH 11RELEASED 11 DATE 11.01.26

PER ECHILL-506

+ ATTACHED EMAIL

Picklist Print

Monday, January 24, 2011 9:00:58 AM

Page 1

Work Order ID: 65707



Parent Item: D4038-4



Parent Item Name: Angle, Aft, RH

Start Date: 1/24/2011

Required Date: 1/26/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	16.9131	0.7	1.473684			
6061T6 ANGLE 4.00 x 4.00 x .250													



11.1.25

Location

MAT

14507

Loc Qty

16.7447

16.7447

MAT06

0.1684

113391

0.1684

Loc Code

1.270

DART AEROSPACE LTD		Work Order: 65707
Description: ANGLE, APT, RH		Part Number: 4038-4
Inspection Dwg:	Rev: PC1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00 ref	+/- .030	3.997	/		QA - 02	
1.25 ref	+/- .030	1.255	/			
1.25 ref	+/- .030	1.245	/			
.250 ref	+/- .010	.240	/			
.25 ref	+/- .030	.250	/			
4.00	+/- .030	3.991	/			
2.904	+/- .010	2.903	/			
.735	+/- .010	.734	/			
.669	+/- .010	.670	/			
.581	+/- .010	.573	/			
.500	+/- .010	.500	/			
1.500	+/- .010	1.500	/			
1.000	+/- .010	.999	/			
2.00	+/- .030	2.000	/			
.500	+/- .010	.500	/			
.316 Ø	+ .006 - .001	.316	/			
.189 Ø	+ .005 - .001	.189	/			
.70	+/- .030	.700	/			
R 1.00	+/- .030	1.000	/			
.50 ref	+/- .030	.500	/			
7.50	+/- .030	7.502	/			
2.125	+/- .010	2.125	/			
.589	+/- .010	.589	/			

Measured by: MD
Date: 11.1.25

Audited by: SL
Date: 11/01/25

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Linda Lacelle

From: Marc Bellavance <mbellavance@dartaero.com>
Sent: January 28, 2011 10:52 AM
To: 'David Shepherd'; 'Harvey Siemens'; Lacelle, Linda
Subject: RE: D130-701-043 Basket

Thanks a bunch guys!

Linda,
Let me know when the W/O's are ready for sign offs.
The D4038 dwg will be released when we get the paperwork back from David early next week.

Marc Bellavance
Technical/Shop Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 243

Cel: 613-676-0992

Fax: 613-632-9311

E-mail: mbellavance@dartaero.com

Web: www.dartaero.com

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From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: January 28, 2011 10:46 AM
To: 'Marc Bellavance'; 'Harvey Siemens'
Subject: RE: D130-701-043 Basket

Yup ... Let's go for it.

David

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Friday, January 28, 2011 8:36 AM
To: 'Harvey Siemens'; 'David Shepherd'
Subject: RE: D130-701-043 Basket

Good news indeed! ☺

So I can print this chain of emails and give the "OK to ship" to Linda then?

Marc Bellavance

Technical/Shop Support

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From: Harvey Siemens [<mailto:hsiemens@dartaero.com>]

Sent: January 28, 2011 10:38 AM

To: 'Marc Bellavance'; 'David Shepherd'

Subject: RE: D130-701-043 Basket

Good news Boss

I was just over at the Hangar checking the last 130 that is here. There is a comfortable 0.375" between the aft tank support and the cowl. So our customer shouldn't have any trouble getting his cowl to fit around the lowered beam.

Regards,

Harvey Siemens

Mechanical Designer

DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

E: hsiemens@dartaero.com

W: www.dartaero.com

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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From: Marc Bellavance [<mailto:mbellavance@dartaero.com>]

Sent: January-28-11 7:34 AM

To: 'Harvey Siemens'; 'David Shepherd'

Subject: RE: D130-701-043 Basket

Thanks Harvey, much appreciated.

Marc Bellavance

Technical/Shop Support

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From: Harvey Siemens [<mailto:hsiemens@dartaero.com>]

Sent: January 28, 2011 9:07 AM

To: 'Marc Bellavance'; 'David Shepherd'

Subject: RE: D130-701-043 Basket

I will attempt to verify that there is enough room in the cowl, first thing this morning and let you know Marc.

Regards,

Harvey Siemens

Mechanical Designer

DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

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From: Marc Bellavance [<mailto:mbellavance@dartaero.com>]

Sent: January-28-11 6:27 AM

To: 'David Shepherd'

Cc: 'Harvey Siemens'

Subject: RE: D130-701-043 Basket

I do not have the means to verify this and honestly thought this was taken into account when I was asked to lower the holes...

Harvey,

Does Eagle have an EC130 available to verify this? Or perhaps with the help of pictures?

The IIN shows a cutout pattern. Maybe all there is to it is increase the cutout by whatever is required?

Or... I can go back to the our unhappy installer and ask...

Marc Bellavance

Technical/Shop Support

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From: David Shepherd [mailto:dshepherd@dartaero.com]

Sent: January 28, 2011 12:11 AM

To: 'Marc Bellavance'

Cc: Harvey Siemens

Subject: RE: D130-701-043 Basket

Marc,

I signed D4038 Rev C tonight. Just occurred to me ... Are we 100% sure there is enough room in the cowlings to drop the beam by 0.125"?

David

From: Marc Bellavance [mailto:mbellavance@dartaero.com]

Sent: Thursday, January 27, 2011 9:15 AM

To: Shepherd, David

Subject: FW: D130-701-043 Basket

Importance: High

Customers are enquiring about shipping...

Thanks,

Marc Bellavance

Technical/Shop Support

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From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: January 26, 2011 3:59 PM
To: Shepherd, David
Cc: Petsche, Mike
Subject: D130-701-043 Basket
Importance: High

Hi David,

As discussed over the phone today, here is the drawing change with ADR and MDL.

Thanks!

Marc Bellavance
Technical/Shop Support

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From: Harvey Siemens [mailto:hsiemens@dartaero.com]
Sent: January 26, 2011 3:08 PM
To: 'Marc Bellavance'
Cc: 'Menard, Jean-Luc'; 'David Shepherd'
Subject: RE: D4038-3/-4 (ref. D130-701 Basket)

Marc

Sounds like we should be ok with that edge distance. I'll leave it to David to make the final call.

Regards,

Harvey Siemens

Mechanical Designer
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From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: January-25-11 9:43 AM
To: Siemens, Harvey
Cc: Menard, Jean-Luc
Subject: D4038-3/-4 (ref. D130-701 Basket)
Importance: High

Harvey,

The revised dimension for the bracket angle is 0.589 which leaves a little more than 1.5 ED.
Hole size is $0.316 \times 1.5 = 0.474$ (0.589 on bracket, was 0.714).
Generally, 1.5 ED is OK but in your opinion, is this good enough or do you recommend increasing to 2X ED?

Marc Bellavance
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